

Work Order ID 52288

Tuesday, September 22, 2009 1:56:25 PM



Page 1

Item ID: D3813-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge, Upper Door

Start Date: 9/23/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

RF-MT

Date:

9-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3813	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

mtf
9/10/28

12

Jcaspa Bandsaw

Cut blank 3.050" " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

10

2

(P10)

HAAS CNC vertical machine #1

1- Mill as per Folio FA779 Rev: *AA* & Dwg D3813 Rev: *A* ☐ 2-Deburr
per dwg D3813 ☐ 3-Finish tapping hole to final depth as per Dwg D3813

inst page

mtf
9/10/28

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

10

2

mtf
9/10/28

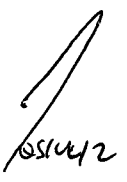
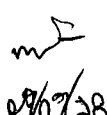
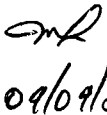

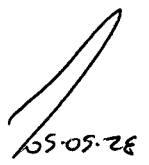
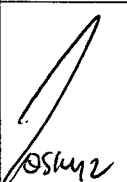

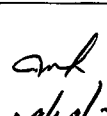

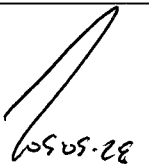
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

only made the 1st one on NCR # 05-10-13

Part No: D3813-1 PAR #: _____ Fault Category: Prod Machine/Parts NCR: Yes No DQA: _____ Date: 05-10-13

Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 07-10-13

NCR: <u>52288</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/27	110	Machine mal-function and piece not machine right. Part has deep "funky" marks in it. KAAS #3. RC: Machine Malfunction.		scrap and replaced qty 1 <u>M 111700</u>	 09/07/28	 09/09/28		 05-05-28
09/07/28	110	1/16 drill broke in piece RC: Process/Tool.		scrap and replace qty 1 <u>M 111700</u>	 09/07/28	 09/09/28		 05-05-28

NOTE: Date & initial all entries

Work Order ID 52288

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Page 2

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Item Name: Hinge, Upper Door

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Required Date: 10/6/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

and 09/09/28

10

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

yl 09/09/30

(x10)

0



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1112260

yl 09/09/30

x10

0



Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE PRIOR TO POWDER COAT☐ START

TIME: *1:15pm* ☐ OVEN TEMPERATURE:

1:45pm ☐ FINISH TIME:

320°F

Work Order ID 52288

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Page 3

Item ID: D3813-1

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	161	00410-01		10			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

9/10/05 K20SP

09/10/06 JH
mf 09-10-05

Picklist Print

Tuesday, September 22, 2009 1:56:25 PM

Page 1

Work Order ID: 52288



Parent Item: D3813-1RevA



Parent Item Name: Hinge, Upper Door

Start Date: 9/23/2009

Required Date: 10/6/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	29.4700	2.6779			



Handwritten signature

6061-T6 Bar 2.50 x 3.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

29.47

102838

13.1

110936

1.03

111700

15.34

mf
04/09/27

~~29.47~~ 3.2025

DART AEROSPACE LTD		Work Order: 52288
Description: Hinge, Upper Door		Part Number: D2813-1
Inspection Dwg: D2813	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.89	±.03	2.90	✓			
1.99	±.03	2.00	✓			
1.55	±.03	1.55	✓			
.90	±.03	.90	✓			
.70	±.03	.69	✓			
.125	±.010	.122	✓			
.56	±.03	.55	✓			
.69	±.03	.68	✓			
3.25	±.03	3.27	✓			
.13	±.03	.12	✓			
.09	±.03	.08	✓			
Ø .06	+ .004 - .001	.06	✓			
Ø .219	+ .005 - .001	.223	✓			
Ø .391	+ .006 - .001	Ø .395	✓			
↓ 1.25	±.03	1.24	✓			
.28	±.03	.27	✓			
.28	±.03	.27	✓			

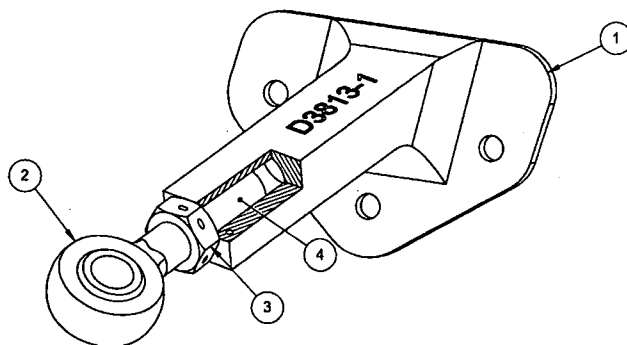
Measured by: <i>mj</i>	Audited by: <i>mj</i>	Prototype Approval:	N/A
Date: 09/09/27	Date: 09/09/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY

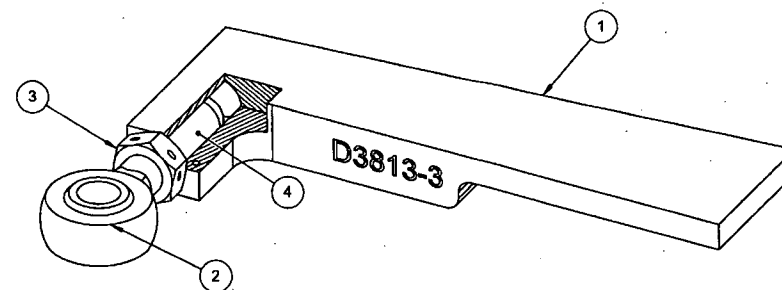
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52288



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR



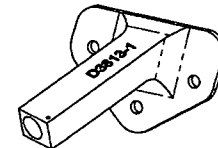
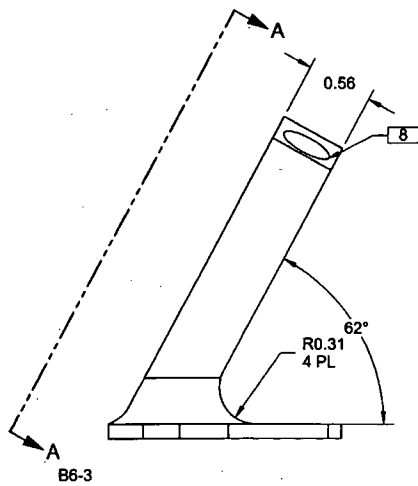
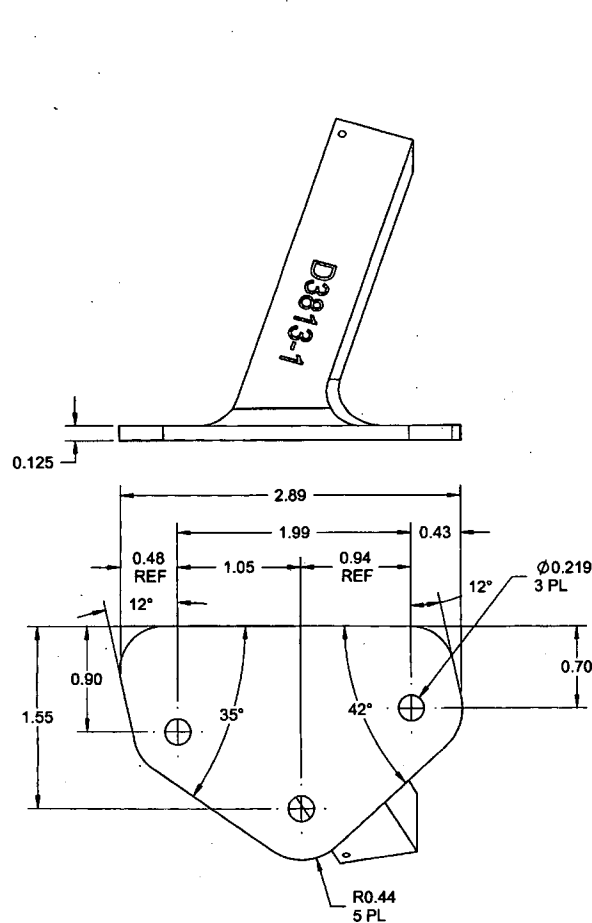
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-043 HINGE ASSY, LOWER DOOR

RELEASED
09/01/13

A	NEW ISSUE	BY <i>[Signature]</i>	DATE 08.11.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE 08.11.10			
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3813		SHEET 1 OF 4	
TITLE HINGE		SCALE NTS	
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32285



D3813-1 HINGE, UPPER DOOR

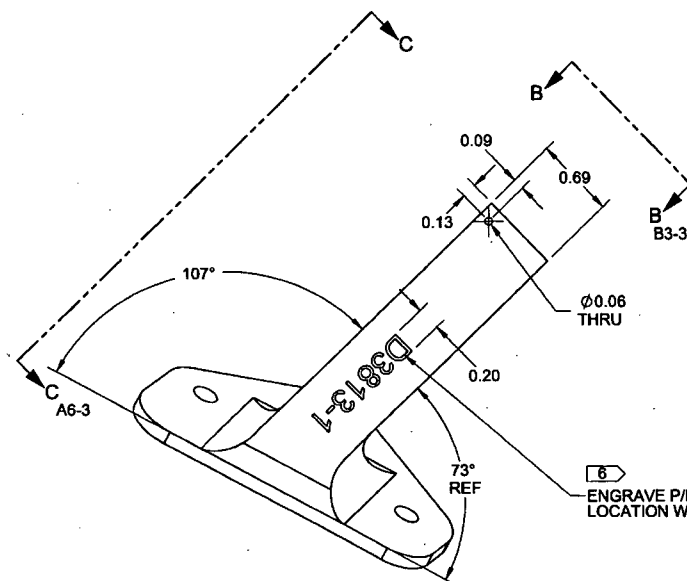
RELEASED
09/01/12

NOTES:

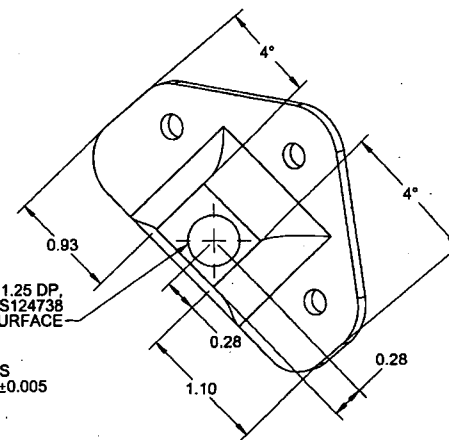
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3813	REV. A
MFG. APPR.		TITLE HINGE	SHEET 2 OF 4
APPROVED			SCALE
DE APPR.			NTS
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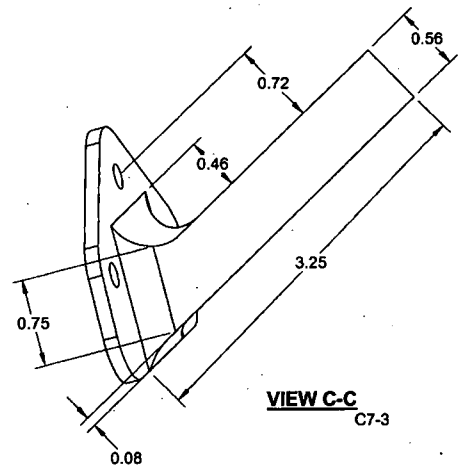
52258



VIEW A-A
C4-2



VIEW B-B
D5-3



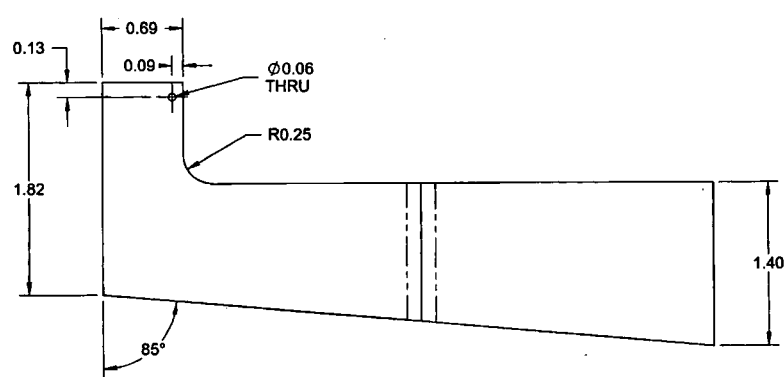
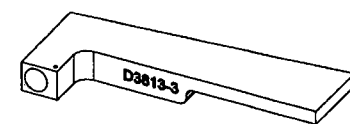
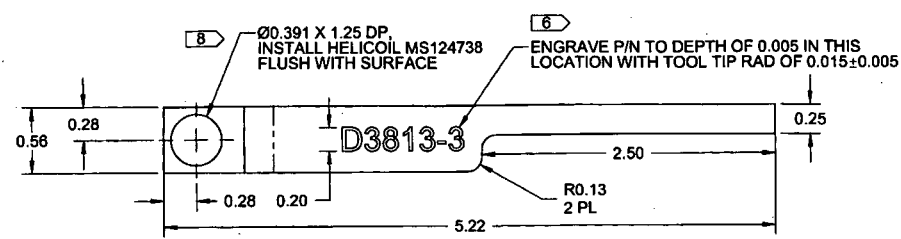
VIEW C-C
C7-3

D3813-1 HINGE, UPPER DOOR

RELEASED
07/01/13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3813	REV. A
MFG. APPR.		TITLE	SHEET 3 OF 4
APPROVED		HINGE	SCALE
DE APPR.			NTS
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522 F8



D3813-3 HINGE, LOWER DOOR

RELEASED
07/07/13 MJD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4118) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3813	REV. A
MFG. APPR.			SHEET 4 OF 4
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DE APPR.			NTS
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